



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3210
Job Sheet 186710



Part No: 646.3210

Job Qty: 12 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV n/c IPP REV:A NEW ISSUE 12-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	12/21/18	12/21/18	0.00	0.00	Start Up Machining-1		SBC 19/02/12
100	Bandsaw	12 pcs	12/21/18	12/21/18	0.00	0.43	Bandsaw1		SBC 19/02/12
110	CNC Vertical Machining	12 pcs	12/21/18	12/21/18	0.32	26.03	HAAS1-1		7/15 19/02/15
130	QC	12 pcs	12/21/18	12/21/18	0.00	0.00	QC8 Machining-1		14 19-02-20
140	Outsource	12 pcs	12/21/18	12/21/18			ATG001-VC	5	19-02-22
150	Packaging	12 pcs	12/21/18	12/21/18	0.00	0.00	Packaging2		MAR 14 2019
155	QC	12 pcs	12/21/18	12/21/18	0.00	0.00	QC5		APR 01 2019
180	Packaging	12 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1		APR 02 2019
190	QC21-SA	12 Ea	12/21/18	12/21/18	0.00	0.00	QC21		APR 02 2019

Part Op 100 - Cut Blank at 10.35"

Descriptions: 110 - 1-Machine per folio FB146

140 - Issue P/O to ATG : _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X1.000	7075-T6S Sheet 6" Thick Plate X 1" Wide	10.3920 ft (.866 ea)	90-Start up Operation	5129445

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X1.000	10	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	5.813Inches ± 0.005	5.818 5.808	5.812	
2	Support	0.250Inches ± 0.005	0.255 0.245	250	Radius
3	Support	0.313Inches ± 0.005	0.318 0.308	3125	Radius
4	Support	0.110Inches ± 0.005	0.115 0.105	108	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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6	Support	0.125Inches ± 0.005	0.130 0.120	.124	
7	Support	0.063Inches ± 0.005	0.068 0.058	.063	
8	Support	0.825Inches ± 0.005	0.830 0.820	.825	
9	Support	3.526Inches ± 0.005	3.531 3.521	3.526	
10	Support	2.465Inches ± 0.005	2.470 2.460	2.465	
11	Support	4.728Inches ± 0.005	4.733 4.723	4.728	
12	Support	0.094Inches + 0.004 - 0.001	0.098 0.093	.094	
13	Support	0.100Inches ± 0.005	0.105 0.095	.096	
14	Support	0.125Inches ± 0.005	0.130 0.120	.125	Radius

Plex 11/20/18 12:42 PM Dart.lajeunesse.marie



Container No: S153194



Part: 646.3210

Job No: 186710

Serial No/Batch: S153194

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 02/12/19

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042670
PO Date: 2/20/19
Due Date: 3/6/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189248	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	10 pcs	0 pcs	10 pcs	\$5.76/pcs	\$57.60
2	186507	D5574-1	Blade Housing, Cable Cutter : Various STC's Issue P/O to ATG Black Anodize & Prime as per Dwg. D5574 Certification of Conformity is required.	Firmed	-	3/6/19	6 pcs	0 pcs	6 pcs	\$11.55/pcs	\$69.30



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189540	C3-8-5	Solenoid Cover Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	10 pcs	0 pcs	10 pcs	\$5.76/pcs	\$57.60
4	186240	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	3/6/19	24 pcs	0 pcs	24 pcs	\$12.00/pcs	\$288.00
5	188674	RB DB3225L-5	Hose End Outsource process-Anodize per QSI017 4.1.10.1 -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	3/6/19	17 pcs	0 pcs	17 pcs	\$6.30/pcs	\$107.10
	189121			Firmed	-	3/6/19	8 pcs	0 pcs	8 pcs	\$6.30/pcs	\$50.40
Sub Total:							25	0	25		\$157.50
6	188306	646.3714	Gusset Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	-	3/6/19	21 pcs	0 pcs	21 pcs	\$17.05/pcs	\$358.05



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PURCHASE ORDER PO042670



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	188703	RBE105-14181W1-9	Drift -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/6/19	4 pcs	0 pcs	4 pcs	\$5.76/pcs	\$23.04
4X FEB 27 2019											
Line Item Note: Need for the 26											
8	188704	RBE105-14181W3-1	Support -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/6/19	4 pcs	0 pcs	4 pcs	\$5.76/pcs	\$23.04
4X FEB 27 2019											
Line Item Note: Need for the 26											
9	186710	646.3210	Support Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	3/6/19	12 pcs	0 pcs	12 pcs	\$15.65/pcs	\$187.80
12X MAR 14 2019											
Grand Total:										\$1,221.93	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042670



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/27/19 10:47 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917440

Date: 13-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
21 ea	Part: 646.3714 ✓ Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24678	Rev: A	PO: PO042670 ✓ Line: 6
12 ea	Part: 646.3210 ✓ Support Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24681	Rev: NC	PO: PO042670 ✓ Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>13/3/19</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			